




CEWELD 21-33Mn

TYPE	Filler metal for heat resistant stainless steel with simmilar nature and composition														
APPLICATIONS	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous invironment. Typical alloy for welding of pyrolysis furnace tubes.														
PROPERTIES	Recommended for operating temperatures up to 1050°C in carburized invironments in ovens in petrochemical plants.														
CLASSIFICATION	EN ISO 14343-A: G Z 21 33 Mn Nb W.Nr. 1.4850 (mod)														
SUITABLE FOR	1.4876, 1.4859, 1.4958, 1.4959, X10NiCrAlTi32-21, GX10NiCrSiNb32-20, X5NiCrAlTi31-20, X8NiCrAlTi32-21, X 12 CrNiTi 18 9 UNS N08800, N08810, N08811 Alloy 800, Alloy 800H, Alloy 800HT, Manaurite 900, Nicrofer 3220 H														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" data-bbox="363 920 1406 987"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>4.6</td> <td>0.28</td> <td>21.2</td> <td>33.2</td> <td>1.2</td> <td>Rem.</td> </tr> </tbody> </table>	C	Mn	Si	Cr	Ni	Nb	Fe	0.1	4.6	0.28	21.2	33.2	1.2	Rem.
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ALL WELD MECHANICAL PROPERTIES	<table border="1" data-bbox="363 1041 1390 1137"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>410</td> <td>620</td> <td>21</td> <td>82</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	As Welded /	410	620	21	82				
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As Welded /	410	620	21	82											
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	I1, I3														



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21-33MN 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663424273